

Work Order ID 63577

Thursday, November 04, 2010 1:08:13 PM



Page 1

Item ID: D3535-35

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 11/4/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

10-11-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3535	Rev B								

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☐ Dwg Rev: *B* ☐ Prog Rev: *B* ☐ 2-
Deburr if necessary*B10-11-11**8**304 .040*

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B10-11-11

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

*8/12/12**28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 63577

Thursday, November 04, 2010 1:08:13 PM

Page 2

Item ID:	D3535-35	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearshoe					
Start Date:	11/4/2010	Start Qty:	8.00		Cust Item ID:	
Required Date:	11/12/2010	Req'd Qty:	8.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC	NC BRAKE	0.00				<u>8</u>			
Brake NC	Memo	0.00							
	1-Deburr if necessary <input type="checkbox"/> 2-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326. <input type="checkbox"/> 3-Identify as D3535-35.								
140  QC	QC5- Inspect part completeness to step on W/O	0.00				<u>8</u>			
Quality Control	Memo	0.00							<u>10/11/15</u>
150  Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00				<u>8</u>			
Powder Coating	Memo	0.00							<u>BL 10-11-17.</u>
	START TIME: <u>12:00</u>								
	FINISH TIME: <u>12:30</u>								
	OVEN TEMPERATURE:								

SB 10/11/15

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 63577

Thursday, November 04, 2010 1:08:13 PM

Page 3

Item ID: D3535-35

Accept

Revision ID:

Item Name: Wearshoe

Start Date: 11/4/2010 Start Qty: 8.00

Required Date: 11/12/2010 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

=> HU 10/11/17

8 0

170



Packaging

Packaging

Identify as per dwg & Stock Location: FP-18 0.00

Memo

0.00

8 BR 10-11-17

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/11/17
MF
10-11-17

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Picklist Print

Page 1

Thursday, November 04, 2010 1:08:17 PM

Work Order ID: 63577

Parent Item: D3535-35

Parent Item Name: Wearshoe



Start Date: 11/4/2010

Required Date: 11/12/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	165.0000	0.8022	6.755368			



304/316 .040 Sheet



18 10-11-11

Location	Loc Qty	Loc Code
MAT	161	
115762	10.2	
115953	150.8	
MAT20	4	
113062	1.398	
115440	2.602	

115953

8

Dart Aerospace Ltd

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DART AEROSPACE LTD		Work Order:	43577
Description: Gasket		Part Number:	D3536-35
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.25	+/-0.030	23.25	✓		T 1801	
19.75	+/-0.030	19.75	✓		T	
17.75	+/-0.030	17.75	✓		T	
14.25	+/-0.030	14.25	✓		T	
9.50	+/-0.030	9.50	✓		T	
4.75	+/-0.030	4.75	✓		T	
2.00	+/-0.030	2.000	✓		V 1802	
6.00	+/-0.030	6.00	✓		T	
6.75	+/-0.030	6.75	✓		T	
0.30	+/-0.030	.304	✓		V	
0.30	+/-0.030	.305	✓		V	
1.89	+/-0.030	1.890	✓		V	
Ø0.19	+0.005/-0.001	.193	✓		V	
0.003 0.040	+/-0.010	.039	✓		V	

10.11.11

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-1-11	Date: 10/1/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	[Signature]

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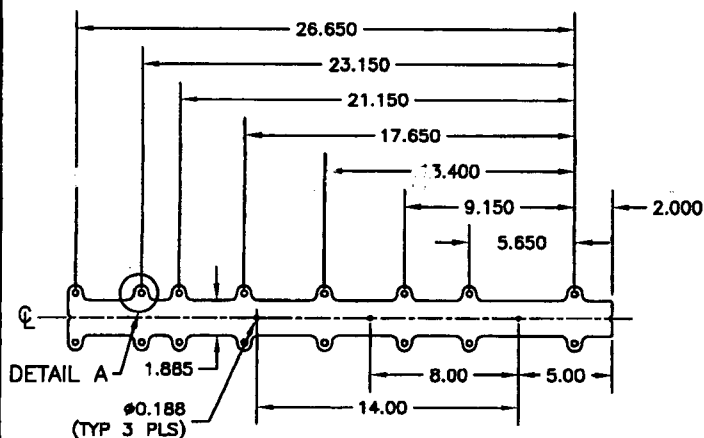
NOTE: Date & initial all entries

DART

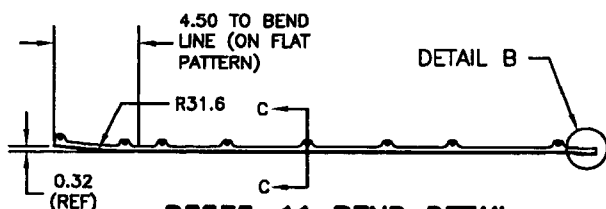
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07.04.24

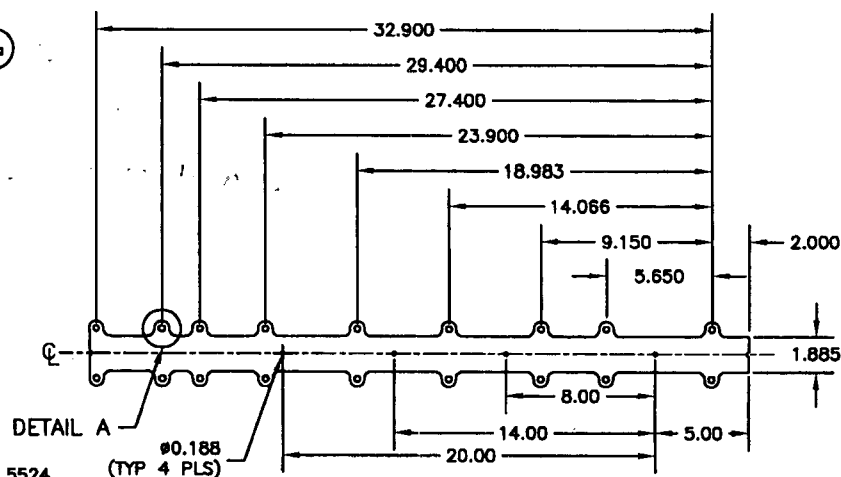
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RETURN)
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63577
2810-11-04



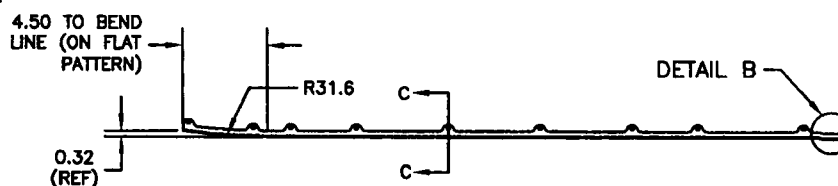
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. B
CB	PH	DRAWING NO. D3535		
CHECKED	APPROVED	TITLE WEARSHOE	SHEET 1 OF 7	SCALE 1:10
DATE 07.04.17				
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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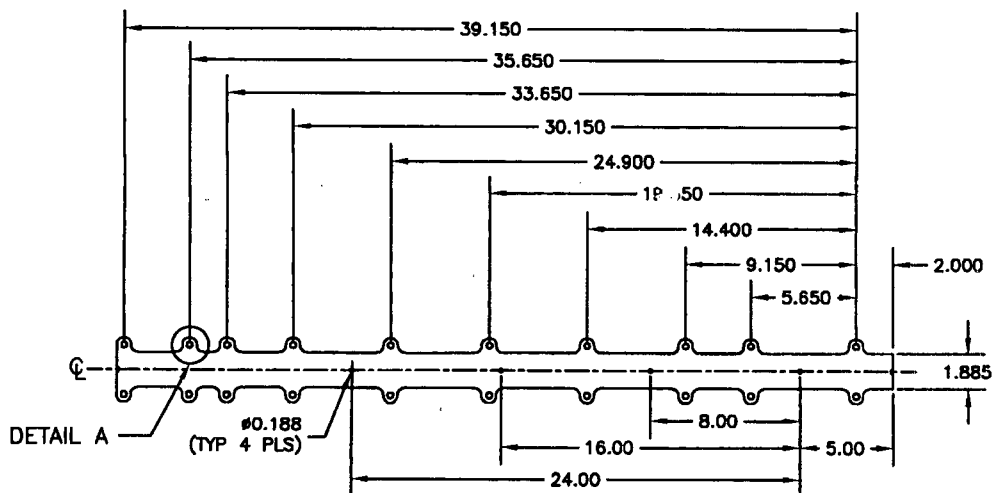
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07.04.24

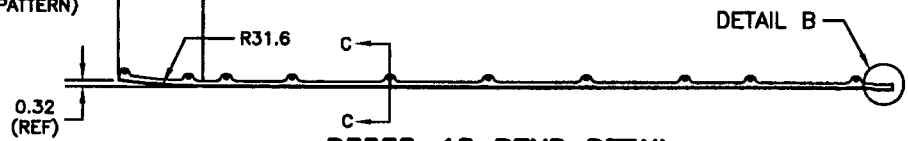
WLO 43577

DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
		REV. B	SHEET 2 OF 7	SCALE 1:10

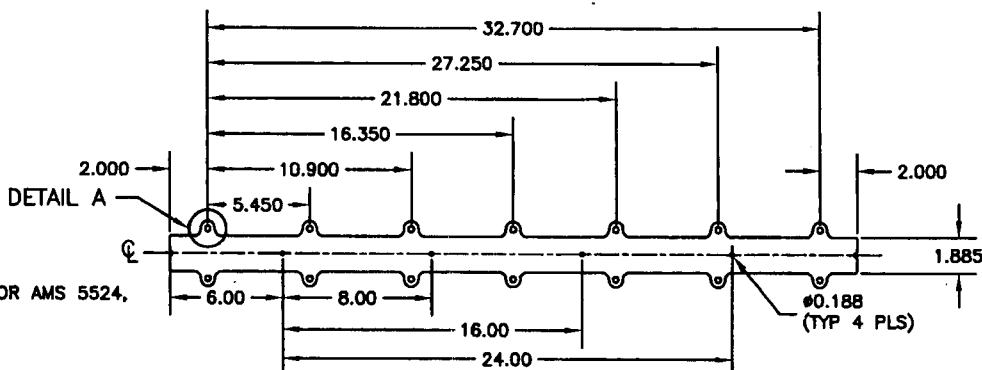


4.50 TO BEND LINE (ON FLAT PATTERN)

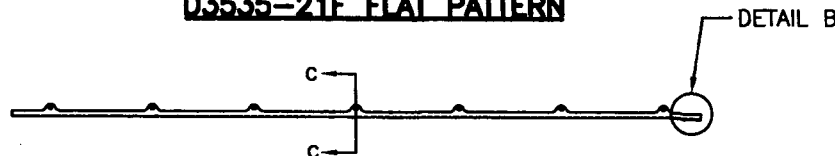
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

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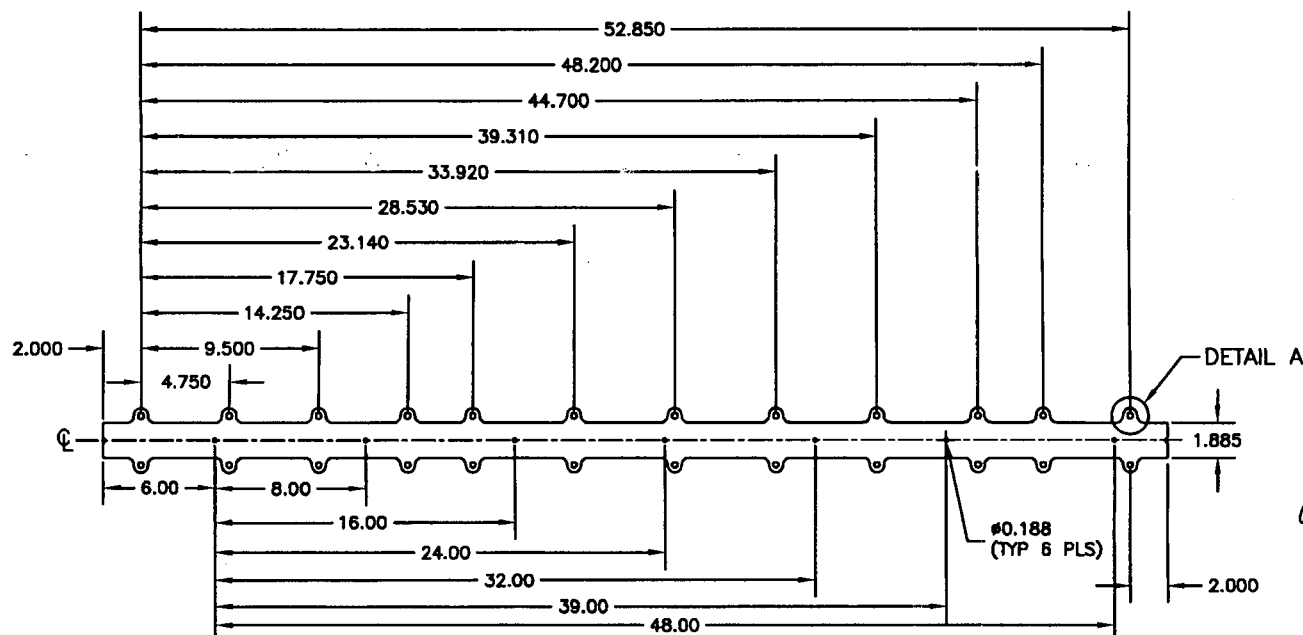
NOTE: Date & initial all entries

DART

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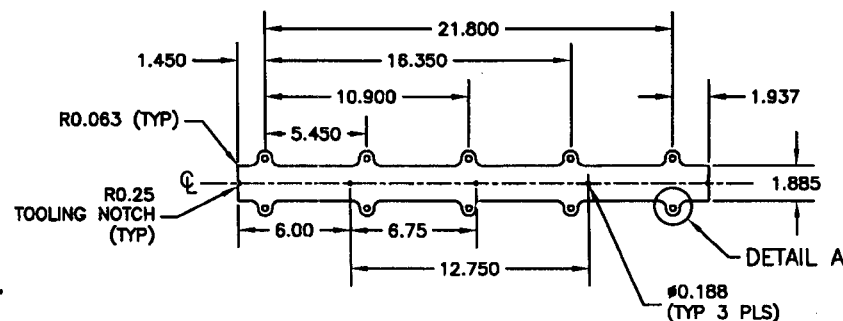
07.04.24

WLG 43577



D3535-23F FLAT PATTERN

D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN

D3535-25 BEND DETAIL

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
#	#	D3535
DATE	TITLE	SHEET 3 OF 7
07.04.17	WEARSHOE	SCALE 1:10

W/O:		WORK ORDER CHANGES					
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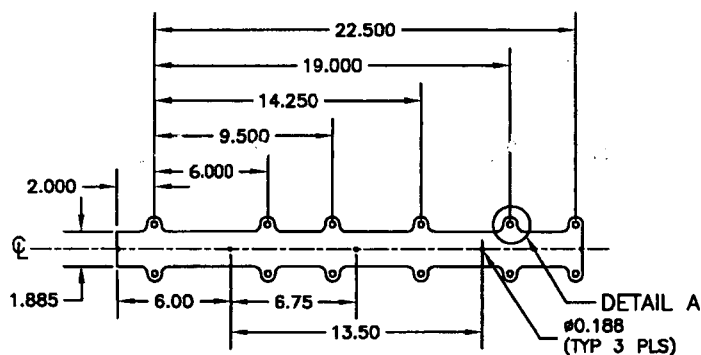
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07.04.24

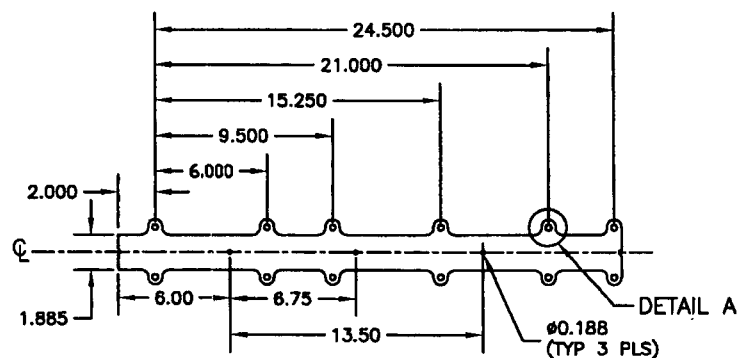


D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL

ULO 43577



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

NOTES

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CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 4 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

Dart Aerospace Ltd

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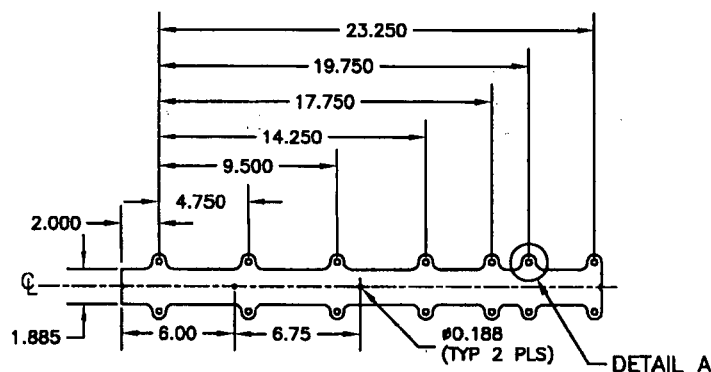
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07.04.17

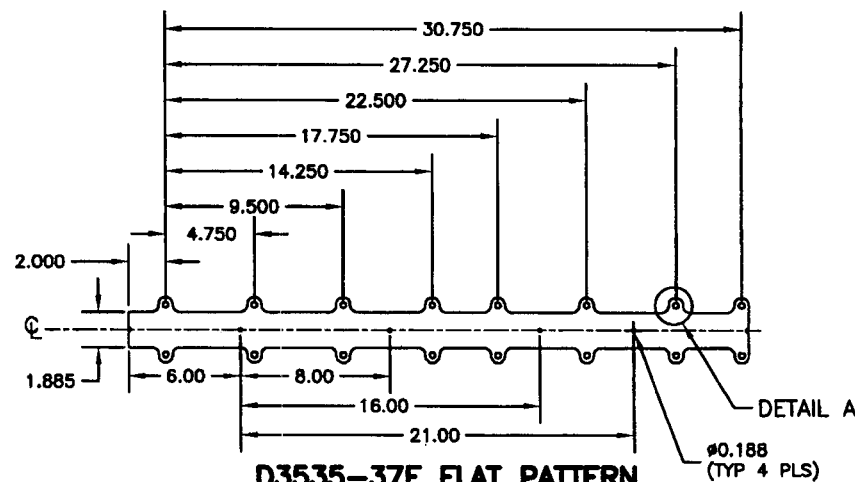
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
		SCALE	1:10	
		SHEET 5 OF 7		
		REV. B		



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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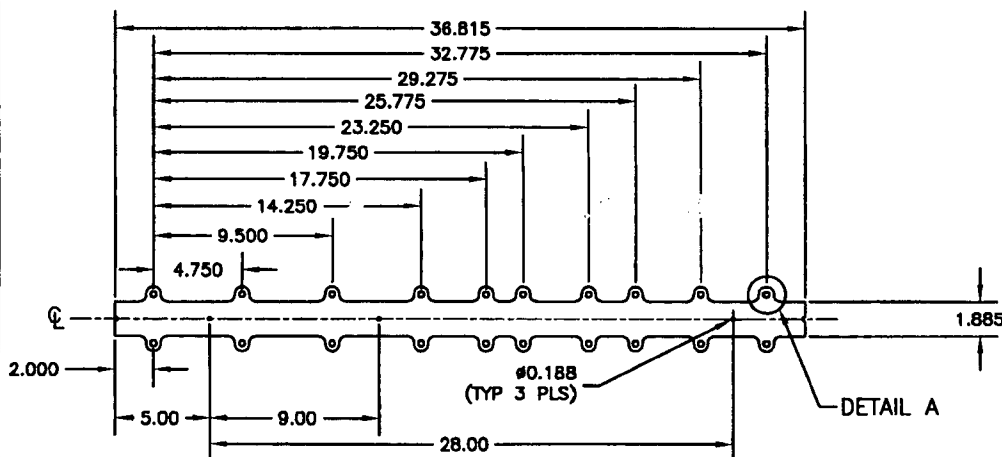
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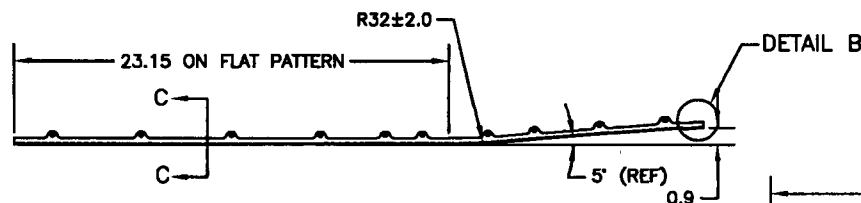
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W/L 43577

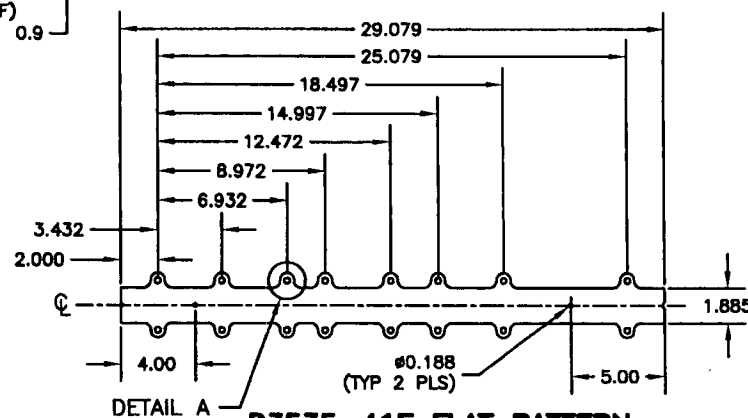
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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
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DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 6 OF 7
		SCALE 1:10



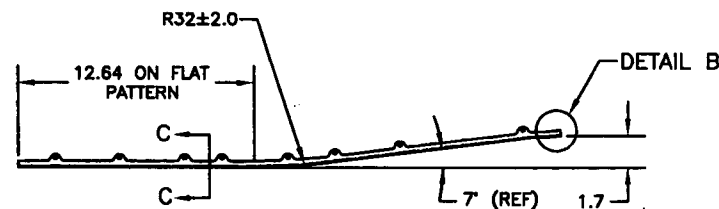
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

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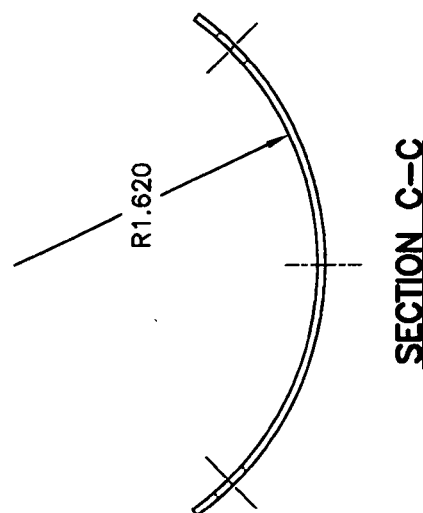
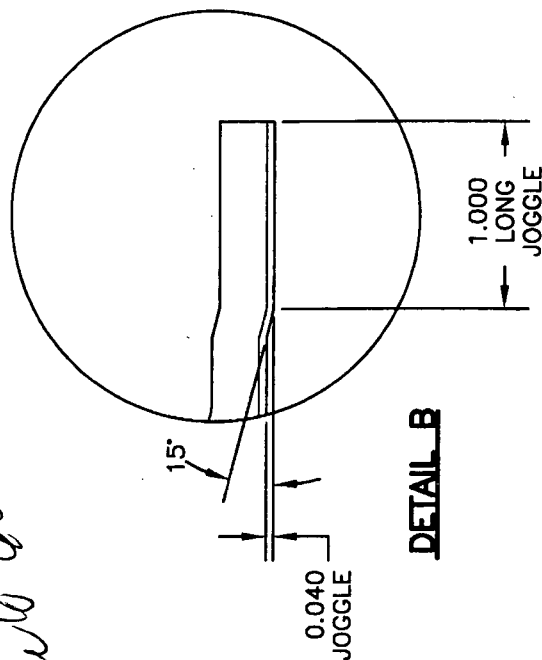
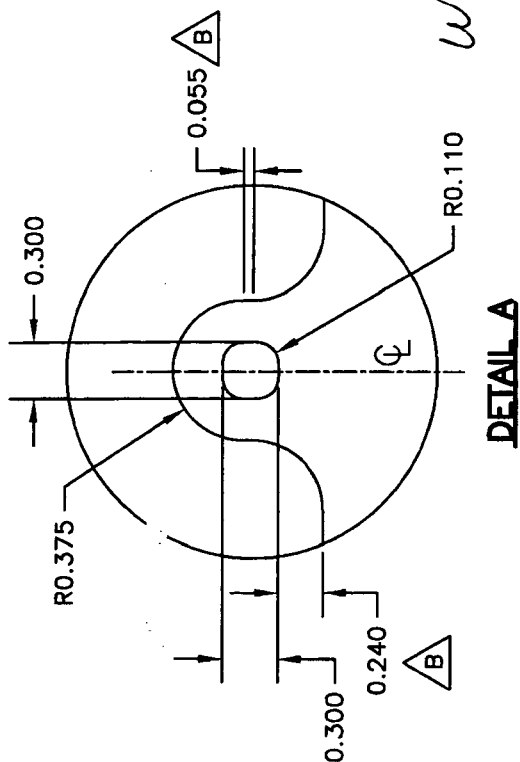


DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1

RELEASED

07.04.24

wh 43577



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries